

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023301**Date Inspected:** 18-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

OBG Segment 13CE / Trial Assembly

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated MT report for this date. The member is identified as OBG 13CE welds as per ZPMC notification # 08861.

The weld designations reviewed are as follows:

SEG3011B-160, 161

SEG3011D-157, 158, 160, 161

SEG3011F-175, 176, 178, 179

SEG3011H-141, 142, 144, 145

SEG3011K-159, 160, 162, 163

OBG Segment 13CE / Trial Assembly

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been

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previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated MT report for this date. The member is identified as OBG 13CE welds as per ZPMC notification # 08860.

The weld designations reviewed are as follows:

SEG3019F-016
SEG3019H-016, 017
SEG3019K-016, 017

OBG Segment 14W / Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of repair weld # SP3103-001-094, as per B-WR # 20449. The welder is identified as 048433. Quality Control (QC) is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G(3F)-FCM-1.

OBG Segment 14W / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of weld # SEG3013U-102. The welder is identified as 066674. Quality Control (QC) is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-TC-U4b-FCM-1.

OBG Segment 14W / Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2F position of weld # Ep3020-001-002. The welder is identified as 066673. Quality Control (QC) is identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS- B-T-2132-ESAB.

Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
